Thursday, 14/08/2008 11:50:04 AM Uşer: # Linda Lacelle **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : HELI-ACCESS STEP LH (FOLDING) Job Number : 41243 Estimate Number : 12567 P.O. Number Part Number : D412630033 This Issue : 14/08/2008 S.O. No. : : IIN D412-630 **Drawing Number** Prsht Rev. : NC Project Number : N/A First Issue : 11 Type : LARGE FAB ASSY **Drawing Revision** : L : 41003 Previous Run Material Written By Due Date : 21/08/2008 Checked & Approved By Comment : Est. Rev:A New Issue 06-11-08 JLM est rev B ecn 1019, added d2807-041 EC verified by:DD **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: 1.0 DC DOCUMENT CONTROL or JUD 08.8.26 Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-033 CHG003 2.0 D2012107 Clevis Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Clevis Pick:

Qty Part Number D2012-107 1

Description Clevis

Batch

3.0 D2803041

Bracket Assembly



1.0000 Each(s)/Unit

Total:

2.0000 Each(s)

Comment: Qty.: **Bracket Assembly** Pick:

> Qtv Part Number D2803-041

Description Bracket Assembly LH Batch

4.0 D2804041

Comment: Qty.:

Bracket Assembly

2.0000 Each(s)

Total:

1.0000 Each(s)/Unit **Bracket Assembly**

Pick:

Qty Part Number D2804-041

Description Bracket Assembly LH Batch

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Date: Thursday, 14/08/2008 11:50:04 AM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: HELI-ACCESS STEP LH (FOLDING) Job Number: 41243 Part Number: D412630033 Job Number: Seq. #: Machine Or Operation: Description: 5.0 D2807041 Door prop Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Support Prop Batch: 6.0 D2813 Washer Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Washer Pick: Qty Part Number Description D2813 Washer 7.0 D3562041 Step Assembly, LH Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Step Weldment LH Pick: Batch 8 4/648 Qty Part Number Description D3562-041 Step Weldment LH 8.0 D33951 Bushing Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s) Bushing Pick: Batch 41 035 Qty Part Number Description D3395-1 Bushing 9.0 AN3C21A BOLT Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) BOLT Pick: Qty Part Number Description 110189 AN3C21A Bolt

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Page 2

W/O:		WORK ORDER CHA	NGES				
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Date:-Thursday, 14/08/2008 11:50:04 AM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: HELI-ACCESS STEP LH (FOLDING) Job Number: 41243 Part Number: D412630033 Job Number: Seq. #: Machine Or Operation: Description: 10.0 AN8C16 Bolt Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Bolt Pick: Qty Part Number Description Batch 2 AN8C16 Bolt 11.0 AN310C8 Nut Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Nut Pick: Qty Part Number Description 10042 2 AN310C8 Nut 12.0 MS24665302 Cotter Pin Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Cotter Pin Pick: Qty Part Number Description Batch M100763 2 MS24665-302 Cotter Pin (or AN380C3-4) 13.0 NAS1515H3 Washer Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s) Washer Pick: Qty Part Number Description 107101 6 NAS1515H3 Washer 14.0 NAS1515H5L WASHER Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s) WASHER Pick: Qty Part Number Description Batch NAS1515H5L Washer

W/O:		WORK ORDER O	CHANGES
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DATE	STEP	Section A			Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

Date: Thursday, 14/08/2008 11:50:04 AM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: HELI-ACCESS STEP LH (FOLDING) Job Number: 41243 Part Number: D412630033 Job Number: Seq. #: Machine Or Operation: Description: 15.0 NAS1515H8 Washer Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s) Washer Pick: Qty Part Number Description Batch M109099 NAS1515H8 Washer 16.0 MS210433 Nut Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s) Nut Pick: Qty Part Number Description MS21043-3 Nut 17.0 MS24693C280 Screw Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Screw Pick: Qty Part Number Description Batch MS24693-C280 Screw (or MS24694-C565) 18.0 SMALL FAB SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per dwg D412-630 p.14 Coat all hardware with LPS3 rust inhibitor A/R LPS3 batch: 19109929 COAT exposed HARDWARE WITH LPS PROCYON. BATCH: 1042 A/R LPS PROCYON 19.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP

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Thursday, 14/08/2008 11:50:04 AM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: HELI-ACCESS STEP LH (FOLDING) Job Number: 41243 Part Number: D412630033 Job Number: Seq. #: Machine Or Operation: Description: PACKAGING 1 20.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Pick Packing Kit 21.0 D28061 Bushing Comment: Qty .: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Bushing Pick: Packing Kit Qty Part Number Description Batch 2 D2806-1 Bushing 22.0 D28063 Bushing Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Bushing Pick: Packing Kit Qty Part Number Description Batch 2 D2806-3 Bushing 23.0 D28105 Strut Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Strut Pick: Packing Kit Qty Part Number Description Batch 40900 D2810-5 Strut 24.0 D33961 Spacer Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Spacer Pick: Packing Kit Qty Part Number Description 2 D3396-1 Spacer 25.0 AN4C6A Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Bolt Pick: Packing Kit Qty Part Number Description Batch Page 5

W/O:		WORK ORDER	CHANGES								
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Date: Thursday, 14/08/2008 11:50:04 AM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: HELI-ACCESS STEP LH (FOLDING) Job Number: 41243 Part Number: D412630033 Job Number: Seq. #: Machine Or Operation: Description: 1 AN4C6A Bolt 26.0 AN4C10A Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Bolt 08/DIN @ Pick: Packing Kit Qty Part Number Description Batch AN4C10A AN4C15A Bolt Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Bolt Pick: Packing Kit Qty Part Number Description Batch M 107080 AN4C15A 2 Bolt AN44C7A Eyebolt Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Eyebolt Pick: Packing Kit Qty Part Number Description AN44-C7A Eyebolt AN5C15A Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Bolt Pick: Packing Kit Qty Part Number Description Batch M105125 AN5C15A Bolt NAS1515H4 Washer Comment: Qty.: 7.0000 Each(s)/Unit Total: 14.0000 Each(s) Washer Pick: Packing Kit Qty Part Number Description Batch M108880 NAS1515H4 Washer

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NCR: WORK ORDER NON-CONFORMANCE (NCR)								
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Date: Thursday, 14/08/2008 11:50:04 AM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: HELI-ACCESS STEP LH (FOLDING) Job Number: 41243 Part Number: D412630033 Job Number: Seq. #: Machine Or Operation: Description: 31.0 NAS1515H5 Washer Comment: Qty.: 7.0000 Each(s)/Unit Total: 14.0000 Each(s) Washer Pick: Packing Kit Qty Part Number Description Batch NAS1515H5 Washer MS210434 Nut Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s) Nut Pick: Packing Kit Qty Part Number Description Batch MS21043-4 Nut MS210435 Nut Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s) Nut Pick: Packing Kit Qty Part Number Description Batch MS21043-5 QC4 Comment: INSPECT 100% KITS FOR COMPLETENESS 35.0 PACKAGING 1 PACKAGING RESOURCE #1 Lobel chedled AS Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-630-033 Location: PPP Rev: 36.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

W/O:		WORK ORDER CH	ANGES		74		
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ		_ Date: _	

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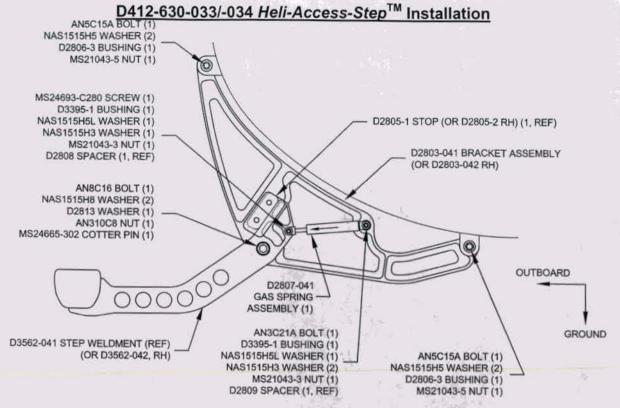


FIGURE 14 - STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation (View rotated 90° CW) AN4C15A BOLT (1) NAS1515H4 WASHER (2) D2806-1 BUSHING (1) SHOP COPY MS21043-4 NUT (1) RETURN TO D2805-1 STOP (OR D2805-2 RH) (1, REF) ENGINEERING AN3C16A BOLT (2, REF) MS24693-C280 SCREW (1) UNCONTROLLED COPY NAS1515H3 WASHER (4, REF) D3395-1 BUSHING (1) MS21043-3 NUT (2, REF) SUBJECT TO AMENDMENT NAS1515H5L WASHER (1) WITHOUT NOTICE NAS1515H3 WASHER (1) D2804-041 BRACKET ASSEMBLY MS21043-3 NUT (1) (OR D2804-042 RH) D2808 SPACER (1, REF) D3562-041 STEP WELDMENT (REF) (OR D3562-042, RH) OUTBOARD D2807-041 GROUND GAS SPRING

FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step[™] Installation (View rotated 90° CW)

ASSEMBLY (1)

NAS1515H5L WASHER (1)

NAS1515H3 WASHER (2)

D2809 SPACER (1, REF)

AN3C21A BOLT (1)

MS21043-3 NUT (1)

D3395-1 BUSHING (1)

AN8C16 BOLT (1)

D2813 WASHER (1)

AN310C8 NUT (1)

NAS1515H8 WASHER (2)

MS24665-302 COTTER PIN (1)

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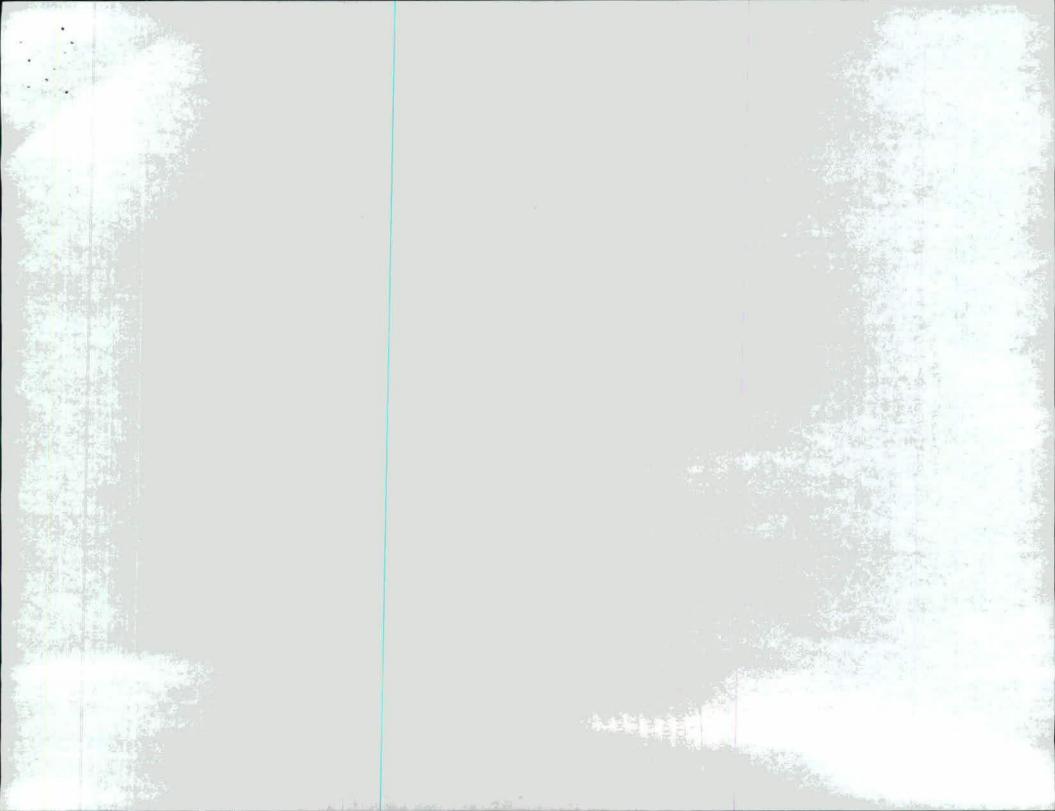
AN4C15A BOLT (1)

MS21043-4 NUT (1)

NAS1515H4 WASHER (2)

D2806-1 BUSHING (1)

Date: 07.09.30



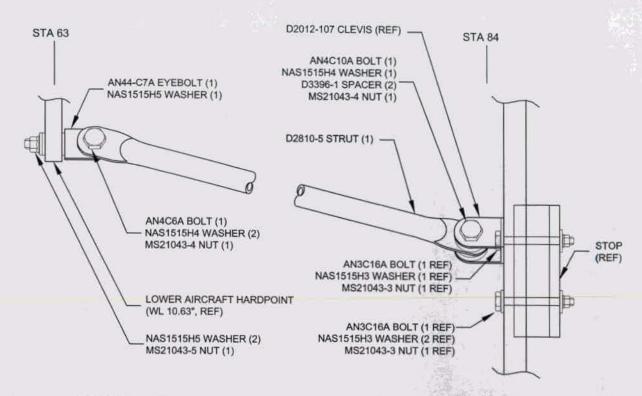
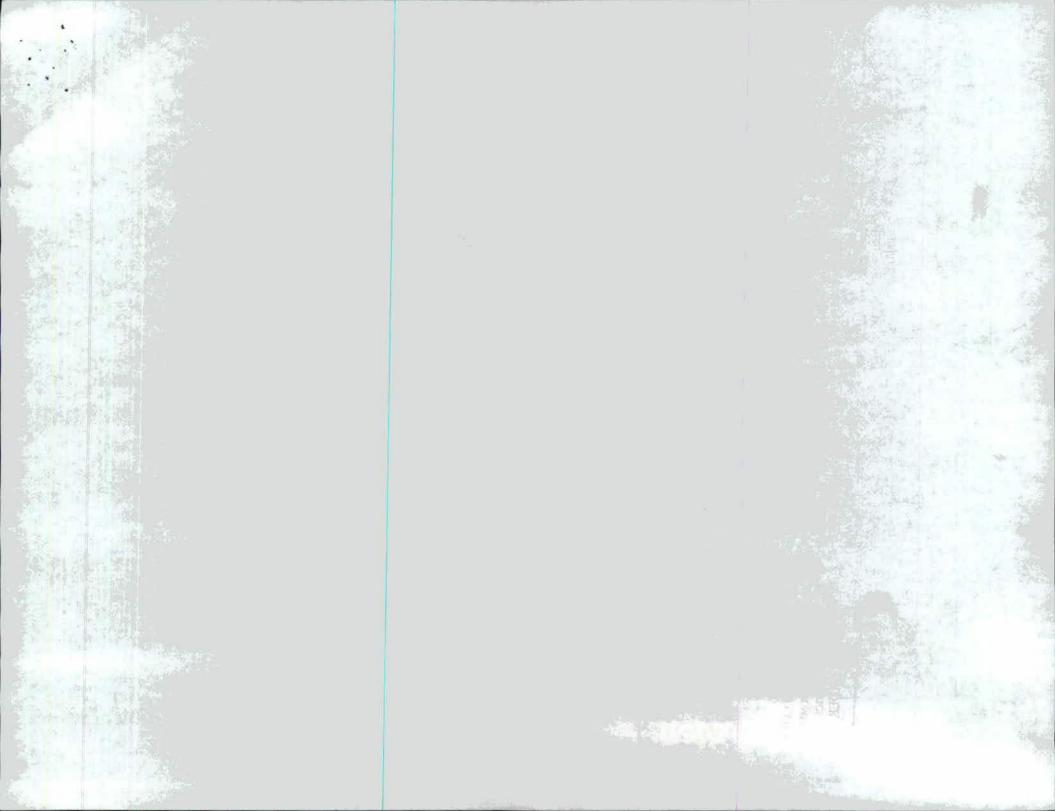


FIGURE 16 – Strut Detail for D412-630-033/-034 Heli-Access-Step[™] Installation (NOT TO SCALE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER



REFERENCE ONLY

